

Date: Thursday, 11/15/2007 1:25:55 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY
 Job Number : 35774
 Estimate Number : 10699
 P.O. Number : N/A Part Number : D3391025
 This Issue : 11/15/2007 S.O. No. : N/A Drawing Number : D3391 REV G
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : G
 Previous Run : 35773 Material : N/A
 Due Date : 12/10/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC
 Est Rev:C 06-03-28 Update Manuf. Instructions JLM

est rev D 07.03.20 revF dwg EC
 est rev E 07.11.07 rev G dwg ecn 1053p EC verified
 by: DD
 Est Rev:F 07-11-13 ECN 1056 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion B26546

Identify as D3391-3

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: G

J.F. 07/11/22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/11/22

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: G

2-Deburr

SB 02.12.05

(1)

325
2535
4.450 MAX
4.560

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:25:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 35774

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 7-12-05

①

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9mk 07/12/05

①

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP

7-12-5

8.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

EL 7-12-5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 7-12-5

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-open wearplate holes to Ø.250 + C'side as per dwg D3391

5-Open up all wearshoe , wearplate and float bag holes as per Dwg D3391.

6-Deburr

Tools: rill

DP
7-12-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 35774

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 Air/yr (X)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DP

7-12-11

13.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: B35813

DP

7-12-11

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: M105379

DP

7-12-11

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 Air/yr (X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105914

FL 07/12/18 (X)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 07/12/18

(X)

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number

Description Batch

1

D2646

Aft Cap

B32427

M. 07/12/18

07/12/18

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 35774

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35371

WEARPAD



m.f.

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPAD

B35696

20.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearpad

B33869

m.f.

21.0

D35531

Gasket



m.f.

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

B32740

22.0

D35533

Gasket



m.f.

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

B33870

23.0

D36721

PHENOLIC WASHER



m.f.

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
PHENOLIC WASHER

B34470

24.0

AELS1032130

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
INSERT
batch: M105729

m.f.

25.0

AELS1032225

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
INSERT

M100489

m.f.

26.0

AN3C4A

BOLT



(IX)

Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Pick:
Qty Part Number Description Batch
2 AN3C4A Bolt

M106431

m.f. 07/12/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 08/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:25:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 35774

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN3C5A

Bolt



*

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt

M106559

m-l

28.0

AN960C10L

washer



*

Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Inventory
Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	

M106575

m-l

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(1X)

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

08/07

M105585

m-l

07/12/18

30.0

QC5

INSPECT WORK TO CURRENT STEP



Inspect inserts
4/12/18

Comment: INSPECT WORK TO CURRENT STEP

5 4/12/18 (1)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

MM

35745

Reson/104

0

32.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

08/11/16

Job Completion



U 08/06/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35774
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: F G Pt 07-11-16	Page 1 of 1	

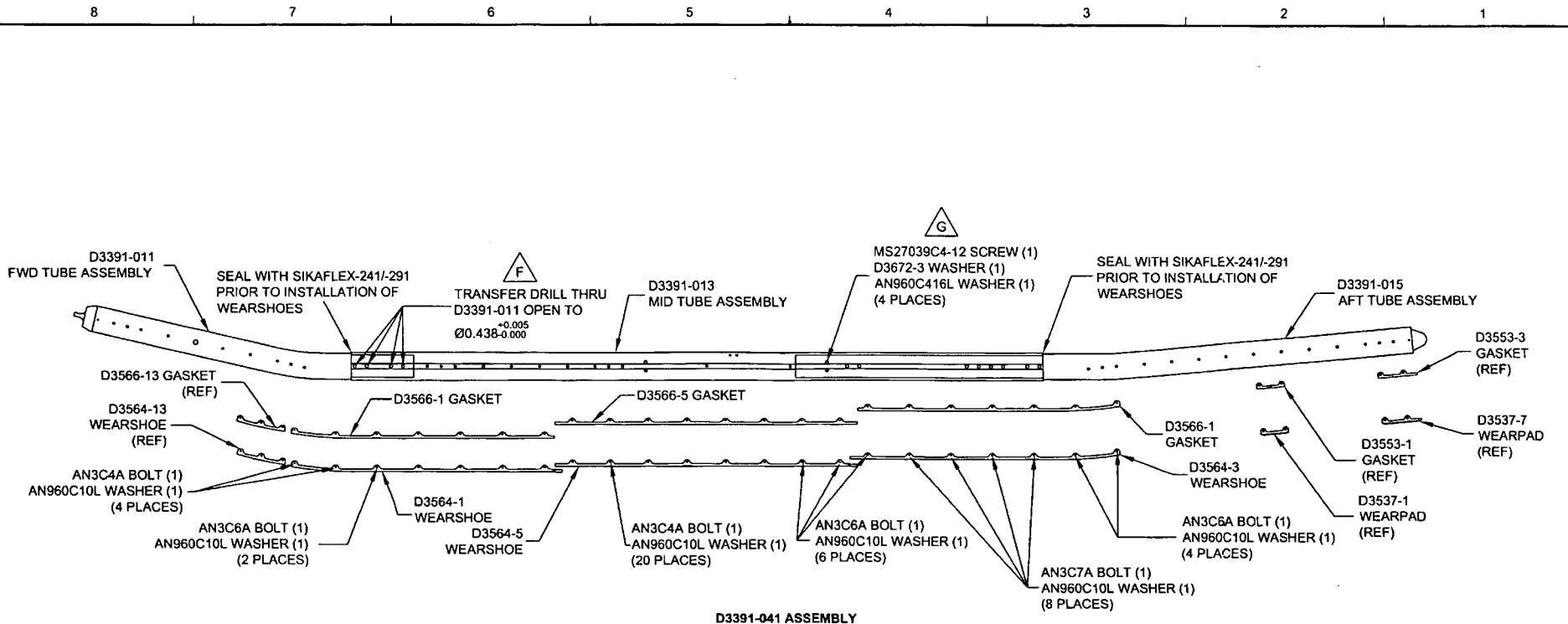
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	13.996"	✓			
3.500	+/-0.010	3.505"	✓			
88.93	+/-0.030	88.940"	✓			
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.204	✓			
1.526	+0.000/-0.030	1.520	✓			
0.200	+/-0.010	.200	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.750	✓			
3.300	+/-0.010	3.298	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.524	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	R.062	✓			
Ø0.484	+0.005/-0.001	.485	✓			

Measured by: J.F./SC	Audited by: JML	Prototype Approval:	N/A
Date: 07/11/22	Date: 07/12/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	EA



RELEASED
07-11-87

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

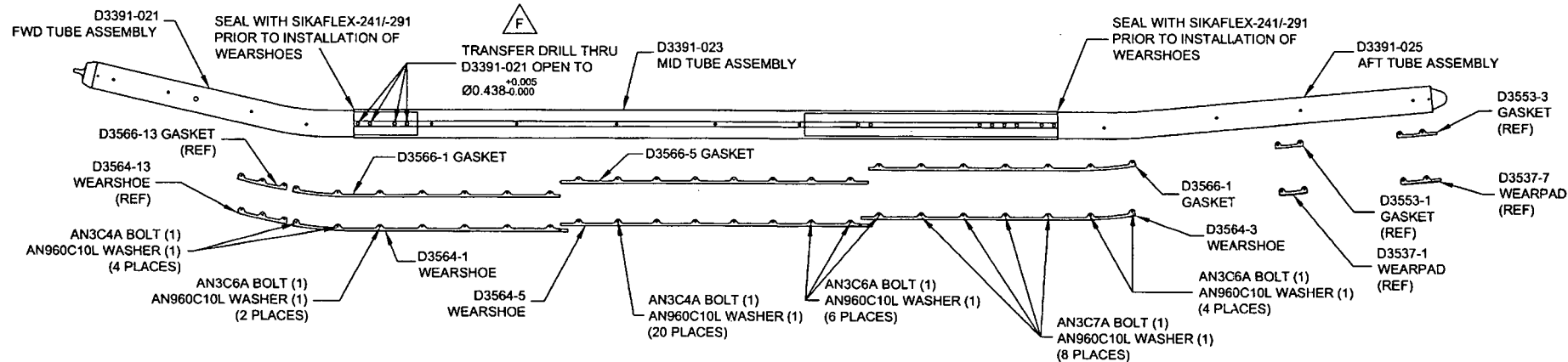
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3391 TITLE 412 FLOAT SKIDTUBE SCALE NTS REV. G SHEET 1 OF 8 COPYRIGHT © 2003 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

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 35227
 WORK ORDER
 WITHOUT NOTICE



D3391-043 ASSEMBLY

RELEASED
07.11.94

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

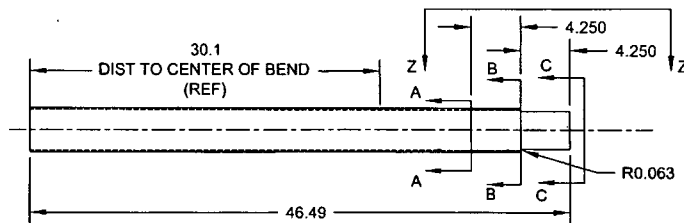
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

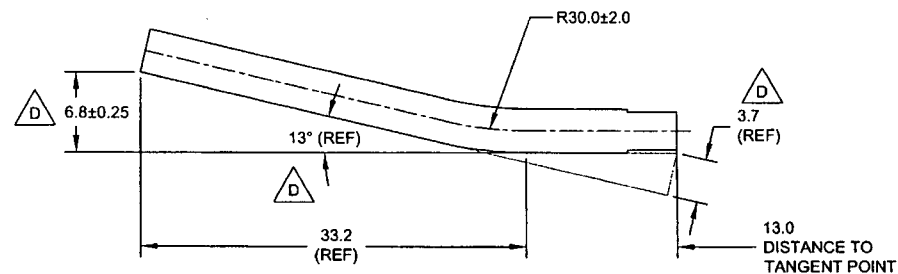
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JLC	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. G
MFG. APPR.	JS	D3391	SHEET 2 OF 8
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

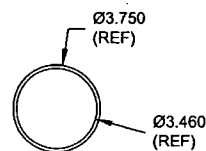
NO. 25774
WORK ORDER
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SUBJECT TO AMENDMENT
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ENGINEERING
RETURN TO
SHOP COPY



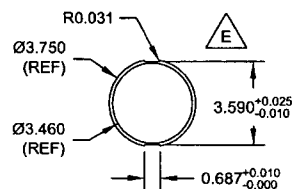
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



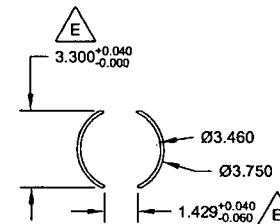
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



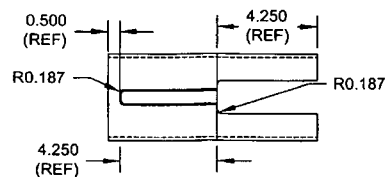
SECTION A-A
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

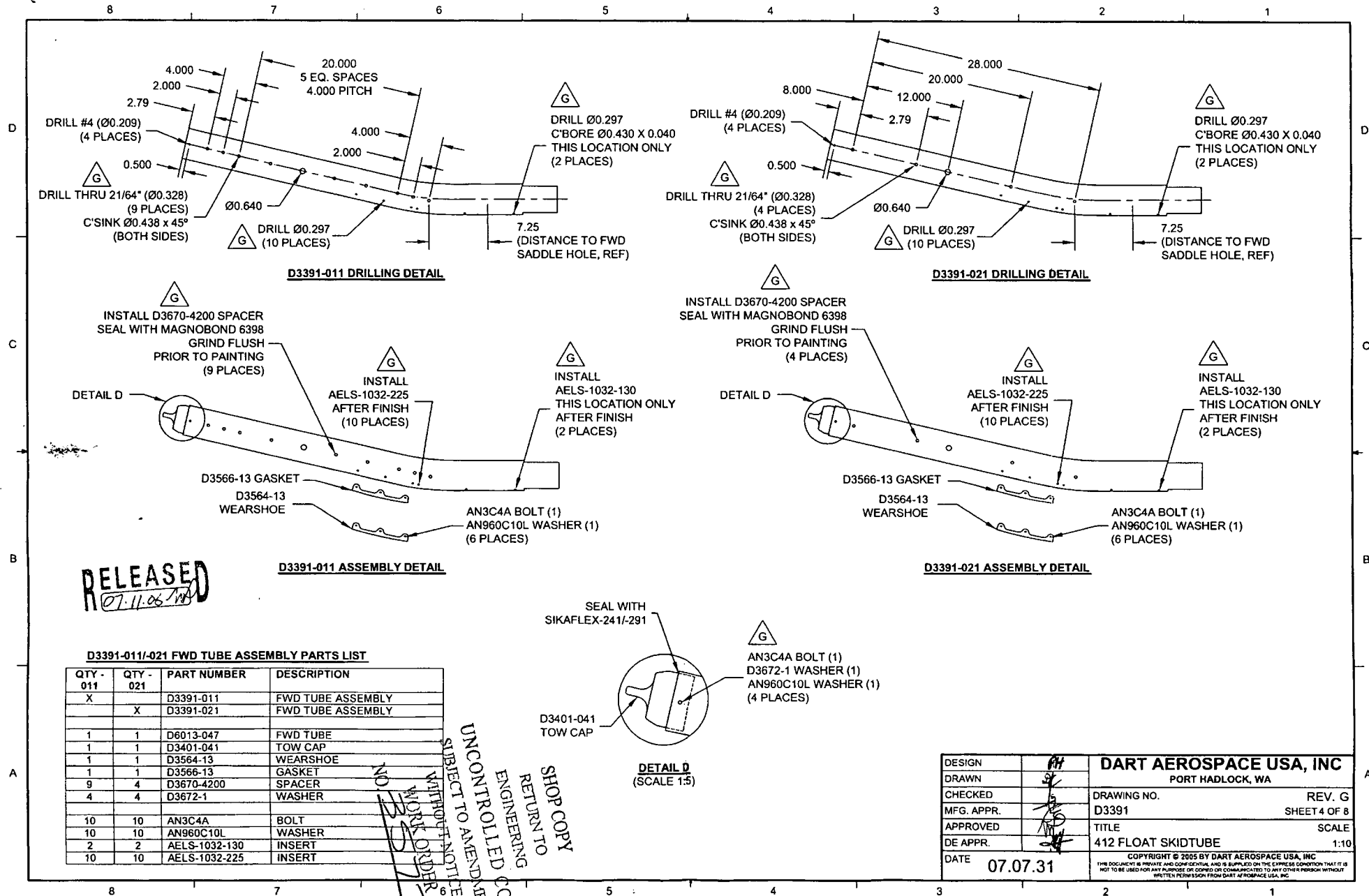


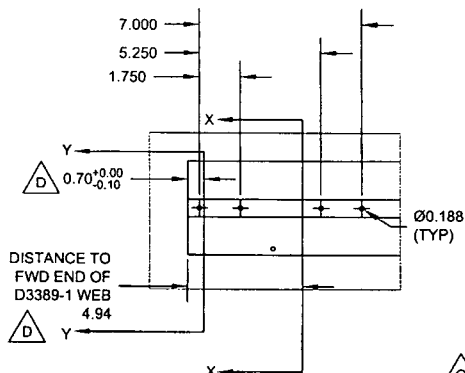
VIEW Z-Z
(SCALE 1:5)

RELEASED
07.11.06

NO. 35724
WORK ORDER
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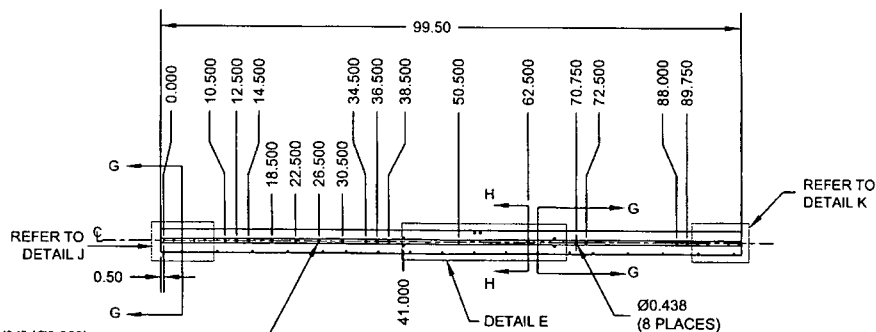
DESIGN		DART AEROSPACE USA, INC	
DRAWN	JH	PORT HADLOCK, WA	
CHECKED	JH	DRAWING NO.	REV. G
MFG. APPR.	JH	D3391	SHEET 3 OF 8
APPROVED	JH	TITLE	SCALE
DE APPR.	JH	412 FLOAT SKIDTUBE	1:10
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	



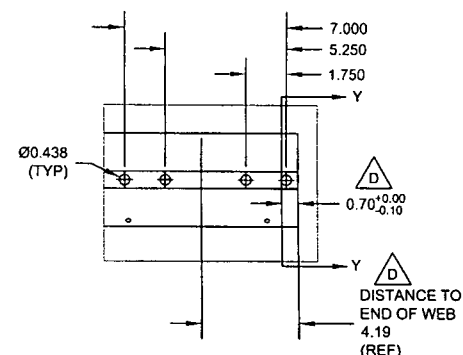


DETAIL J
(SCALE 1:5)

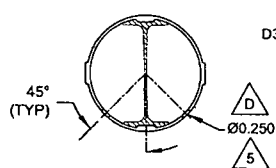
DRILL THRU 21/64" (Ø0.328)
C'SINK Ø0.438 X 45° (BOTH SIDES)
(12 PLACES)



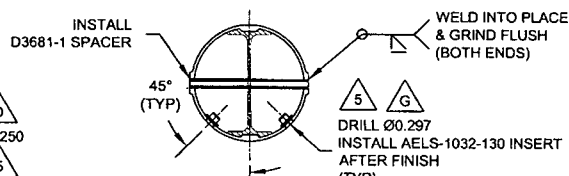
D3391-013 ASSEMBLY DETAIL



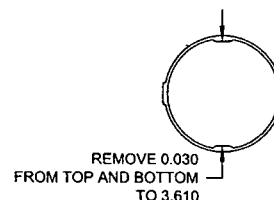
DETAIL K
(SCALE 1:5)



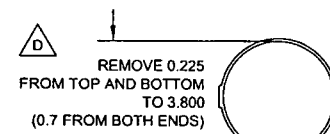
SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)

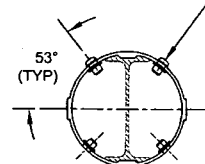


SECTION X-X
(SCALE 1:4)

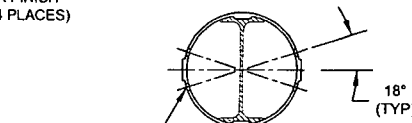


SECTION Y-Y
(SCALE 1:4)

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
(TYP 4 PLACES)



SECTION M-M
(SCALE 1:4)



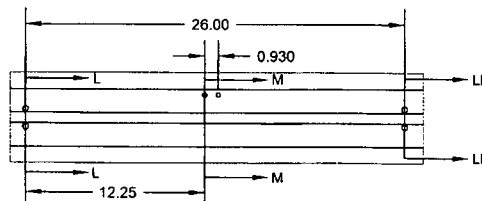
SECTION LL-LL
(SCALE 1:4)

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

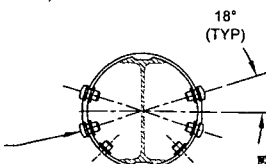
D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004



DETAIL E
(SCALE 1:8)

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
(TYP 4 PLACES)

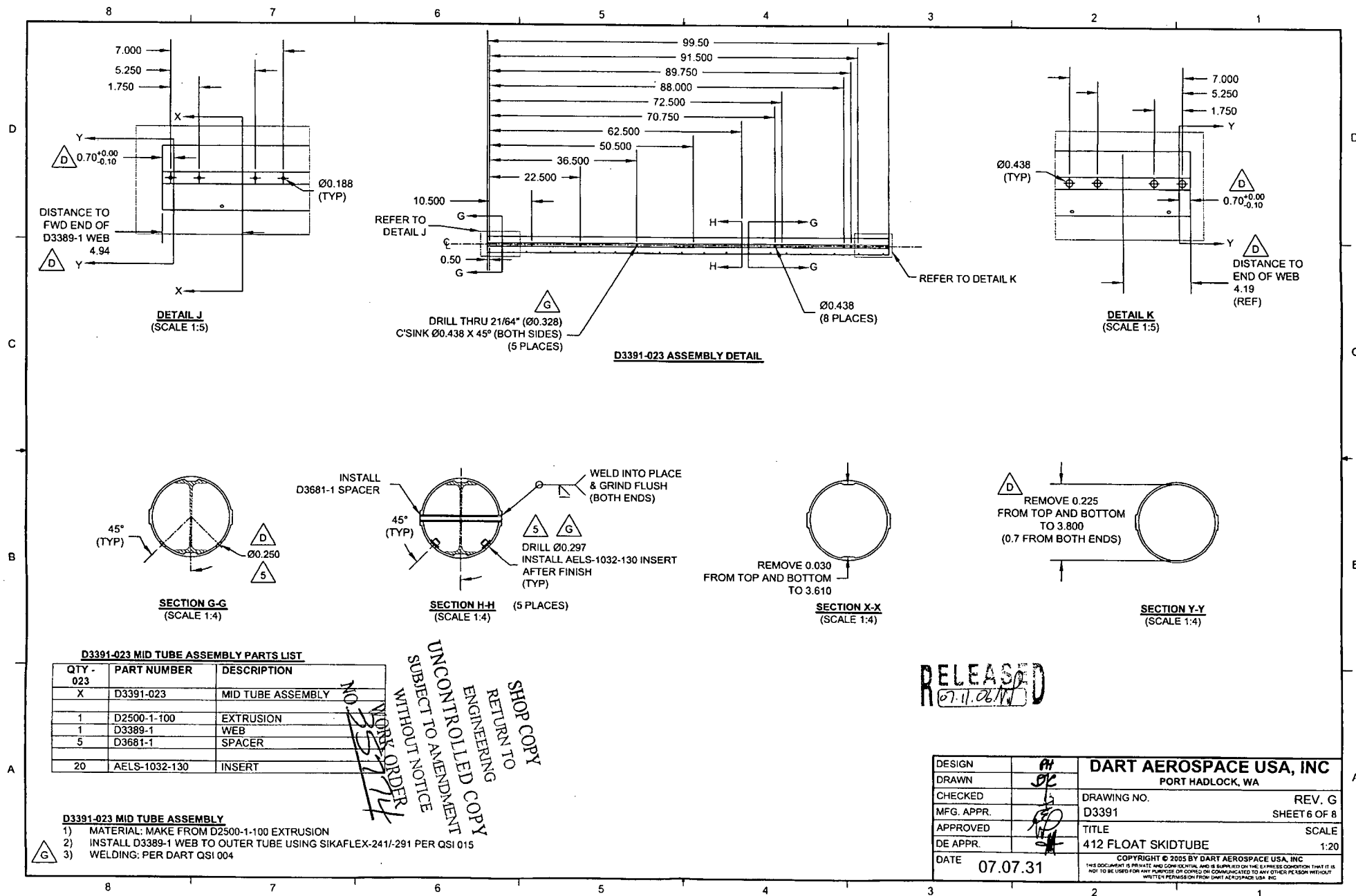


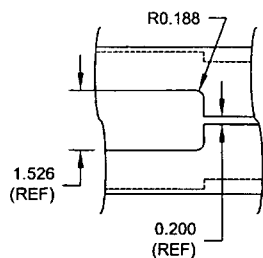
SECTION L-L
(SCALE 1:4)

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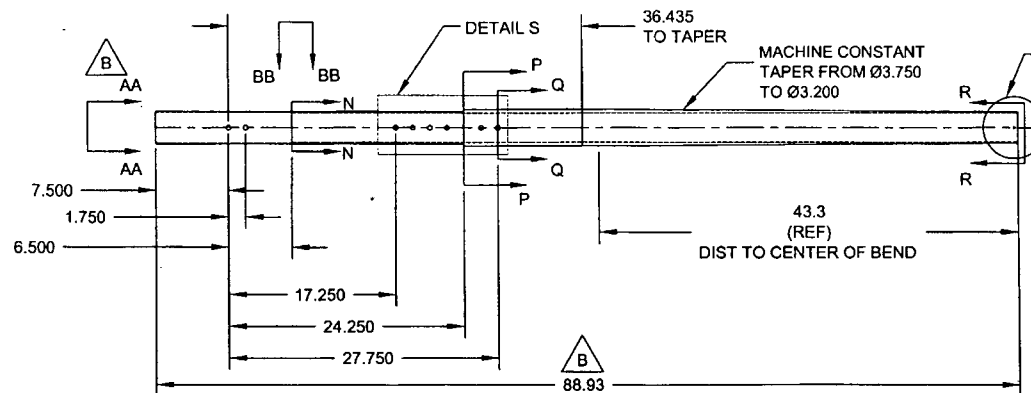
DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	DP	PORT HADLOCK, WA
CHECKED	J	DRAWING NO. D3391
MFG. APPR.	100	REV. G SHEET 5 OF 8
APPROVED		TITLE 412 FLOAT SKIDTUBE
DE APPR.		SCALE 1:20
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

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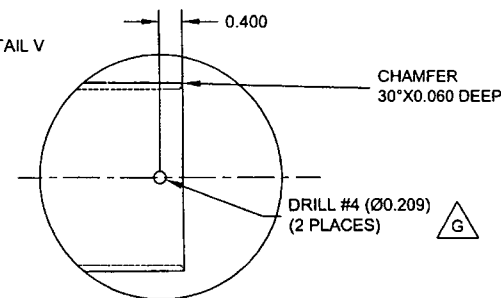




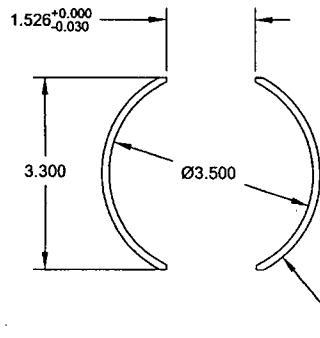
VIEW BB-BB
(SCALE 1:3)



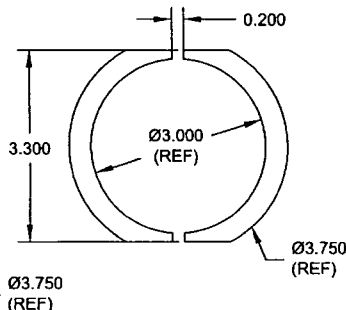
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



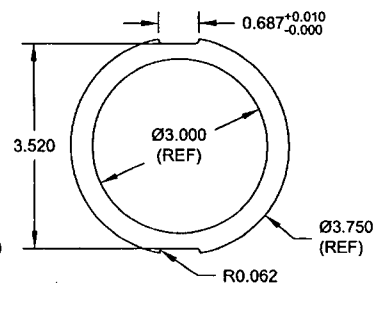
DETAIL V
(SCALE 1:2)



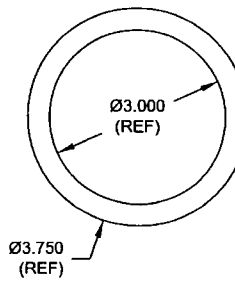
SECTION AA-AA
(SCALE 1:2)



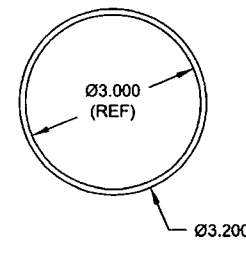
SECTION N-N
(SCALE 1:2)



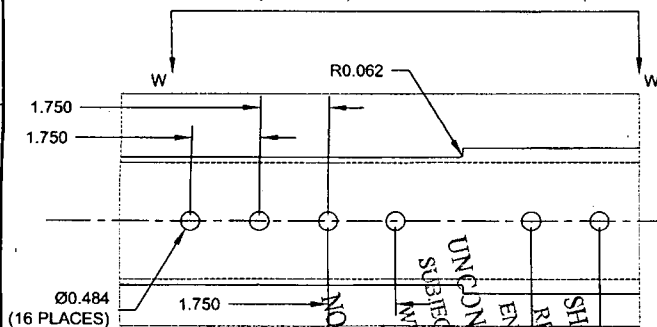
SECTION P-P
(SCALE 1:2)



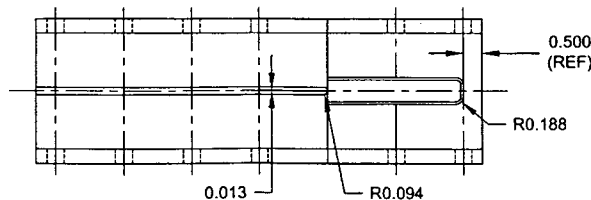
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)

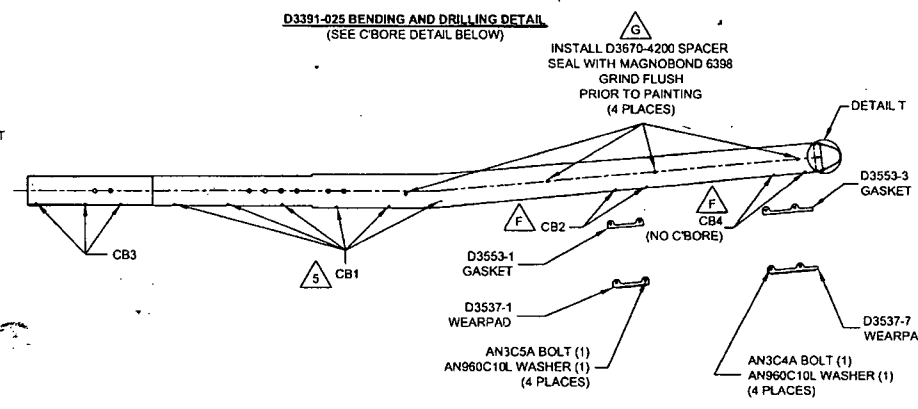
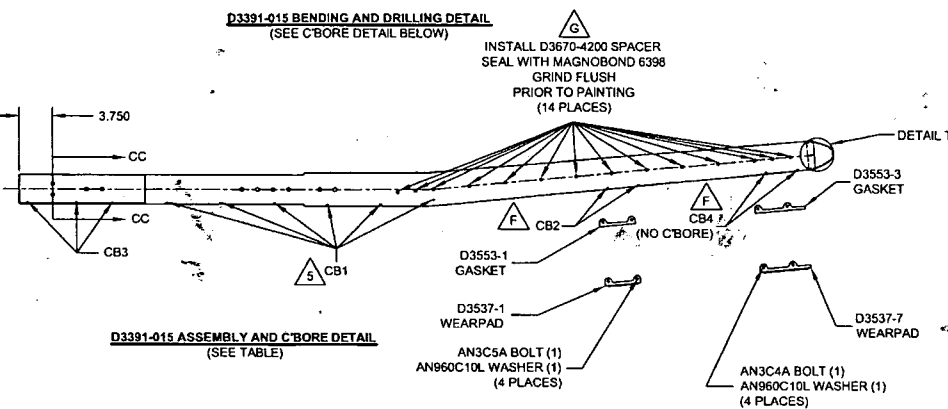
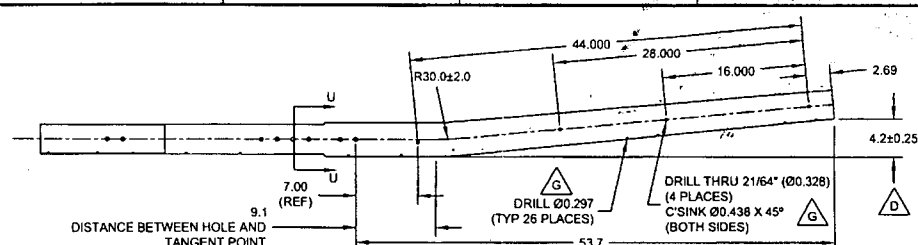
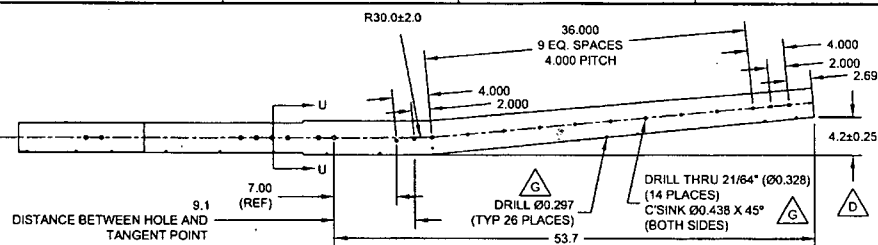


VIEW W-W
(SCALE 1:3)

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DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. G
MFG. APPR.		TITLE 412 FLOAT SKIDTUBE	SHEET 7 OF 8
APPROVED		SCALE	1:12
DE APPR.		DATE 07.07.31	
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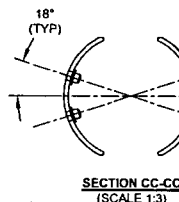
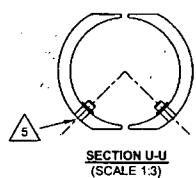


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

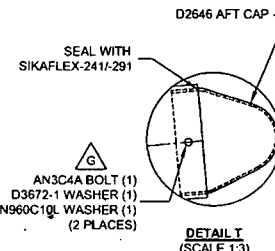
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2846	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130



DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)



RELEASED
07-11-06

DESIGN	TH	DART AEROSPACE USA, INC	
DRAWN	SK	PORT HADLOCK, WA	
CHECKED	SK	DRAWING NO.	REV. G
MFG. APPR.	SK	D3391	SHEET 8 OF 8
APPROVED	SK	TITLE	SCALE
DE APPR.	SK	412 FLOAT SKIDTUBE	1:12
DATE	07.07.31	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC	

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